

Date: Tuesday, 4/18/2006 10:02:57 AM  
User: Kim Johnston

# Process Sheet

20

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH AFT X-TUBE 412
Job Number	: 26672		
Estimate Number	: 10559		
P.O. Number	: N/A	Part Number	: D412664203
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D412-664-243 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 25653	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/15/2006
Checked & Approved By	: <u>06.04.18</u>	Qty:	1 Um: Each
Comment	: Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003

KS 06-05-10

2.0	D6009129	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube 25942

Check OD = 3.500"; ID = 2.250"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

M8 06/05/13 1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

M8 06/05/13 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:58 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26672

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3-Polish entire outside surface of crosstube

4- Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

MS 06/05/13 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/05/13 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 06.05.17 1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 BT 06-05-17

9.0

QC3/5

INSPECT WORKWING WALK



Comment: Inspect work & Chemical conversion Coat

DP 06-5-18

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 06-5-23

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-05-31

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26672

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 *RT 06-05-31*

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check *RT 06-05-31* dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 *Pm 06-05-31 (1)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

14.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: *1386* LPI as per ASTM 1417 *C206/06/02 (1)*

Level 2 Attach copy of NDT results to work order

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order. *✓ Al 06/06/09 (1)*

16.0

*006*

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 *06-06-12 (1)*

17.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 *FC 06 06 19*

2-Paint outside crosstube with White Imron as per QSI 005 4.2 *MA BB 15 (1)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
060601	13.1	Add QCS before NOT. Permanent change <i>[Signature]</i>				<i>[Signature]</i>	<i>[Signature]</i> 060601	
060612	16	QC5 - Remove QCB Permanent change <i>[Signature]</i>					<i>[Signature]</i> 060612	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/06/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26672

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC14

Inspect Spray Paint



*06-21 (1)*

Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

19.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip B25656 IT 06-06-22

20.0

D2856600

Abrasion Strip



Comment: Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s)

Pick:

Qty Part number Description Batch

1 D2856-600(Cut to 10.870") Abrasion Strip B25656 IT 06-06-22

21.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support B26683 IT 06-06-22

22.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield B26687 IT 06-06-22

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M00479 06-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:58 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26672

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-30 Clamp M100154 JT 06-06-22

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203 25 06-06-22

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-6-28

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M100327 ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M9633 ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M100191 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26672

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M19099 ✓

PC 6/6/28 (1)

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AL 06/06/28 (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location: /

PPP Rev: 0

PC 6/6/29 (1)

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/29 (1)

Job Completion



86-0629

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26672
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b> D412-664-243
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688	✓			
	2.748	+0.005/-0.000	2.753	✓			
	2.884	+0.005/-0.000	2.889	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.167	✓			
	3.308	+0.005/-0.000	3.310	✓			
	3.429	+0.005/-0.000	3.431	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.623	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.971	+/-0.001	4.971	✓			
	2.684	+0.005/-0.000	2.688	✓			
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.888	✓			
	3.019	+0.005/-0.000	3.023	✓			
	3.163	+0.005/-0.000	3.168	✓			
SIDE C	3.308	+0.005/-0.000	3.312	✓			
	3.429	+0.005/-0.000	3.432	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.620	✓			
	0.200	+/-0.010	.200				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.971	+/-0.001	4.971	✓			
	124.09	+/-0.020	124.09				

<b>Measured by:</b> BG/M8	<b>Audited by:</b> BG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/05/13	<b>Date:</b> 06-05-17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.06.09 [Signature]

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTINAL TO TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

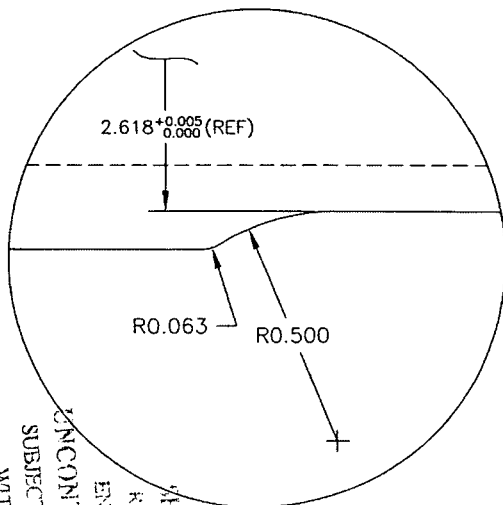
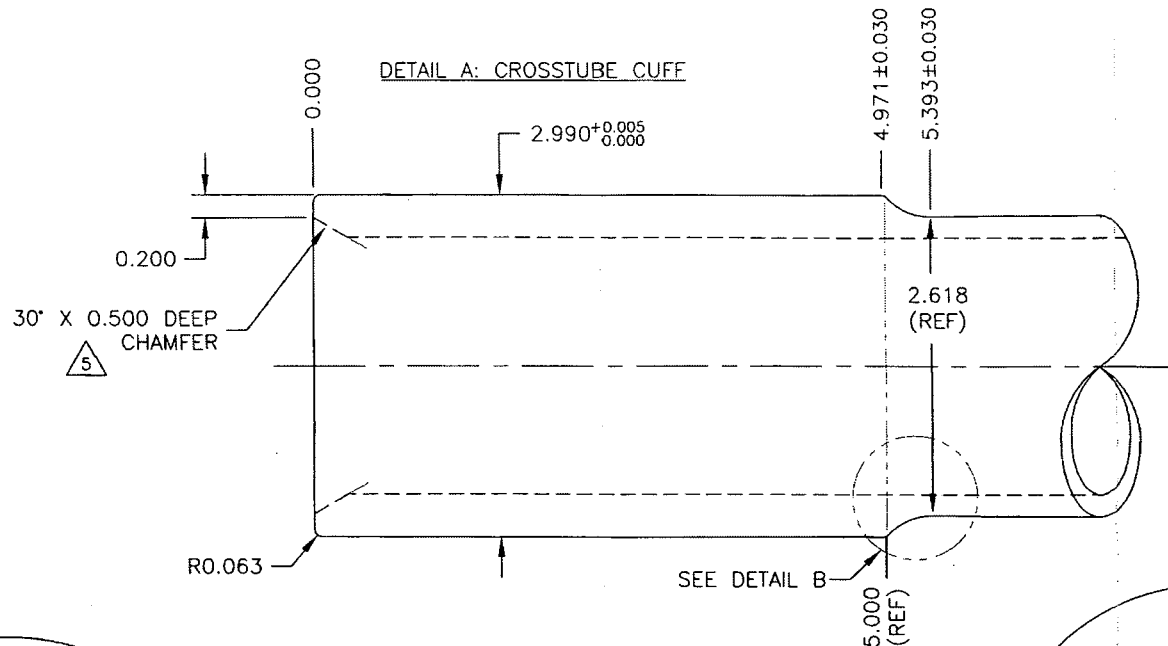
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26672

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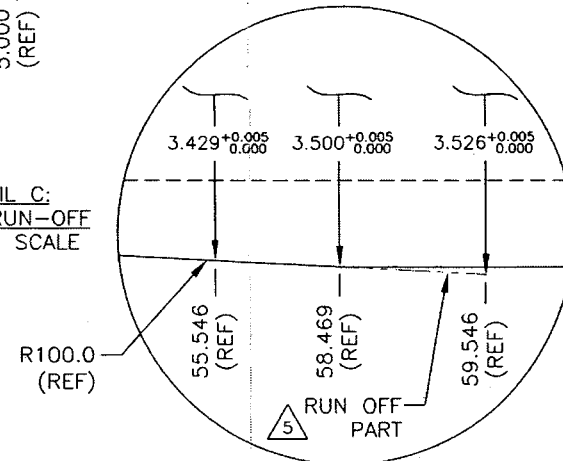
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RELEASED  
05.06.01

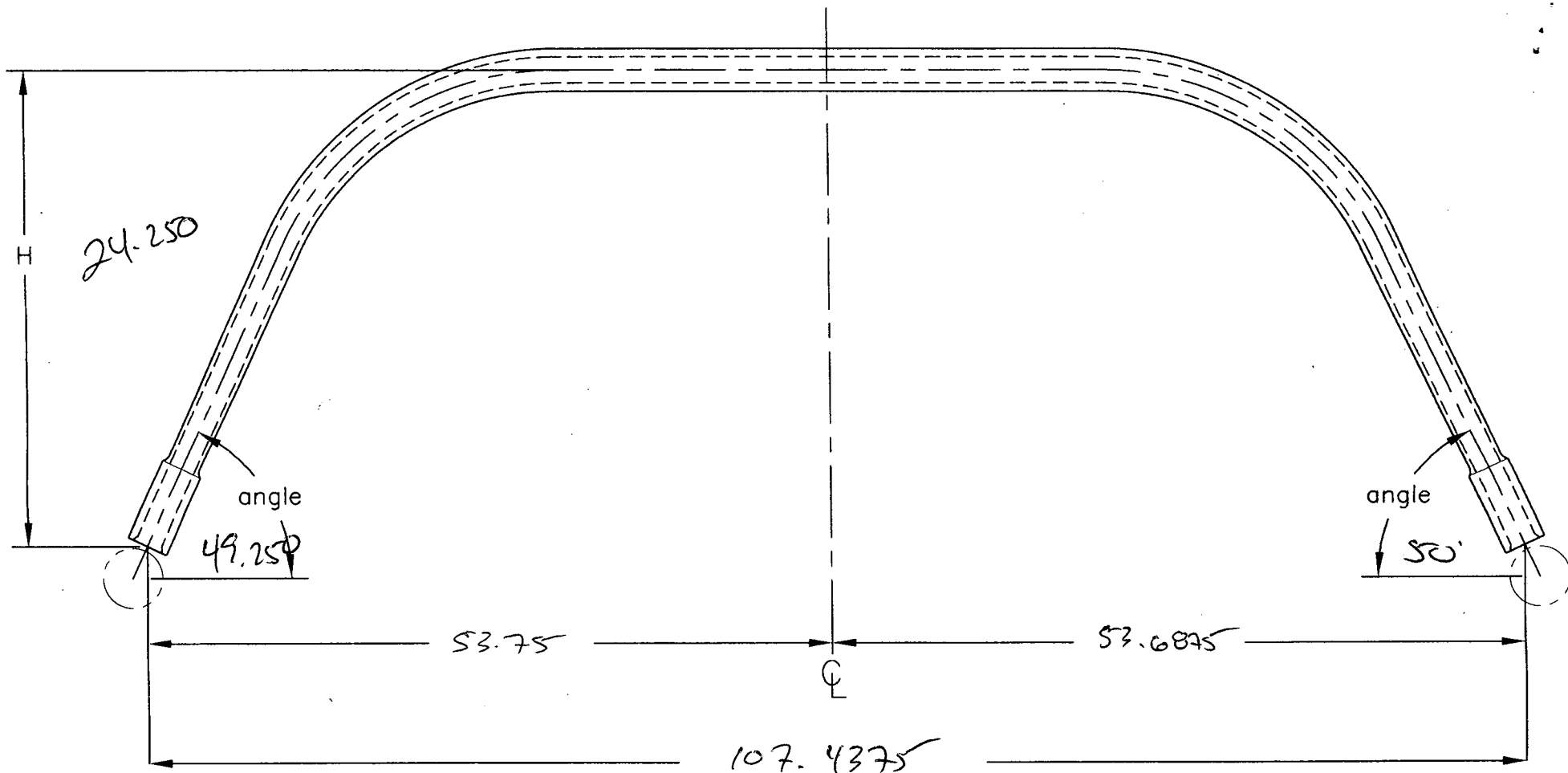


DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



COPYRIGHT © 2001 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH	DRAWING NO. D412-664-243	REV. B SHEET 3 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)		SCALE 1:1			

NO. 26672  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



DATE: 06-05-31

DESCRIPTION: ~~26672~~ 412-664-203

BATCH NO: 26672

DRAWING: 412-664-243 R.B

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE:  $50^\circ \pm 2$

*[Signature]*  
06-05-31



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34275

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (12) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630

Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (12) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE June 8, 2006

INSPECTION STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

1386

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT